

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025502**Date Inspected:** 21-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang xing Island in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 204730 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 West (AW). Joint identified as SA3154-001, 002, 003, 004, 006, 008. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 045175 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 West (AW). Joint identified as SA3154-005, 007. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-ESAB.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 067947, 045196 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 West. Joint identified as DP3126-101, 102. ZPMC CWI

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-4314-Tc-U4b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 058102 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 East. Joint identified as SEG3011Z-261. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang: 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

---